



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBEA62309
Job Sheet 170532



Part No: RBEA62309

Job Qty: 1 ea

Part Name: AS350/355 Field Maintenance



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/17/18

Job Tracking No:

Due Date: 2/9/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: RBEA62309 rev.12 IPP REV:A 17.12.13 NEW ISSUE DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Start up Operation	1 Ea		2/8/18			DAR001-VU		
110	Small Fab	1 pcs		2/9/18	0.00	1.00	Small Fab-9		
120	QC	1 pcs		2/9/18	0.00	0.00	QC5		
130	Packaging	1 pcs		2/9/18	0.00	0.00	Packaging3-2		
140	QC21-FG	1 Ea		2/9/18	0.00	0.00	QC21		

Part Op 110 - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case

Descriptions: APP-1700-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Install placard to wheel housing as per DWG 6-Glue foam to case and pack case 7- See note 1 for hoses

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
100-Start up Operation	97524A032	4	259	0	0
	APP-1700-E	1	0	0	0
	RB41011	1	955	0	0
	RBE-350DAMPER	1	0	0	0
	RBE-350HYD	1	0	0	0
	RBE-350INCLINOMETER	1	0	0	0
	RBE-350TDRS	1	2	0	0
	RBE-350TEMP	1	0	0	0
	RBE350A93-3200-20	1	0	0	0
	RBE350A93-3205-00E	1	0	0	0
	RBE350A93-3205-00T	1	0	0	0
	RBE350A93-3300-20	1	0	0	0
	RBE350A93-3302-02	1	0	0	0
	RBE350A93-3303-02	1	0	0	0
	RBE350A93-3305-20	1	0	0	0
	RBE350A93-3307-00	1	0	0	0
	RBE350A93-3312-03	1	0	0	0
	RBE350A93-3316-20	1	0	0	0
	RBE350A93-3317-20	1	0	0	0
	RBE350A93-3400-00	1	0	0	0
	RBE350A93-3500-00	1	0	0	0
	RBE350A93-3501-20	1	0	0	0
	RBE350A94-2704-00	1	0	0	0
	RBE350A94-2706-00	1	0	0	0
	RBE350A94-2708-01	1	0	0	0
	RBE350A94-3301-00	1	0	0	0
	RBE350A94-3700-A	1	0	0	0

DART
AEROSPACE

Container No: S056920

Part: RBE462309

Job No: 770532

Serial No/Batch: S056920

Revision: 12

Inspector:

DART Aerospace Ltd.
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Date: 03/29/18

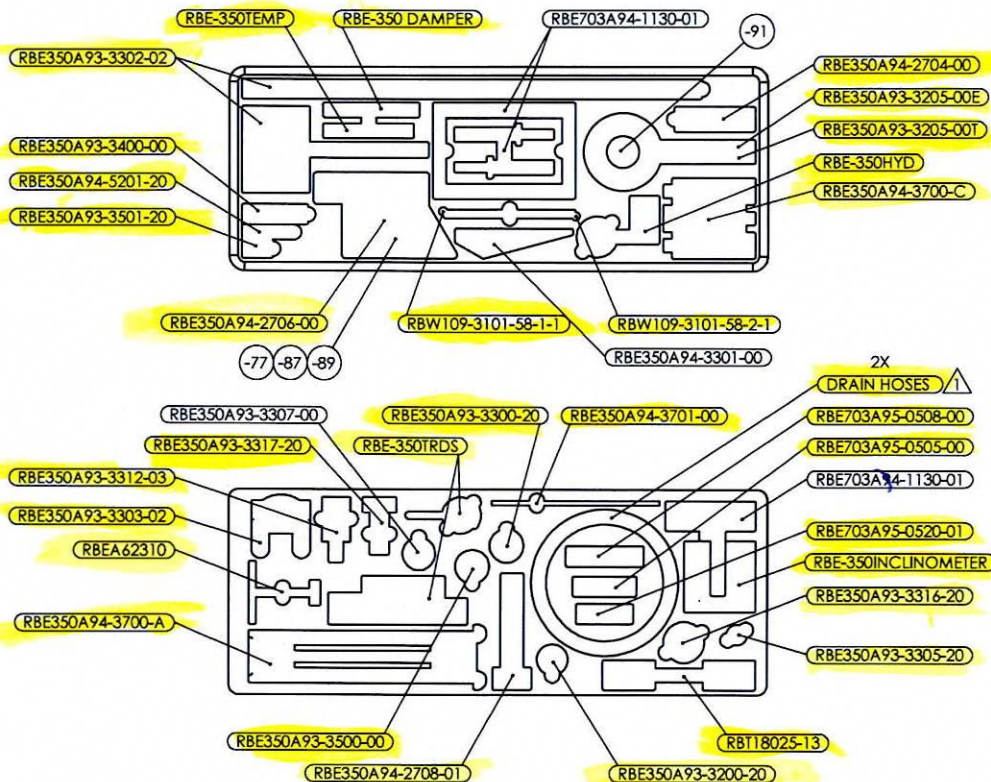
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03
9-88

	RBE350A94-3700-C	1	0	0	0
5041674	RBE350A94-3701-00	1	0	0	0
	RBE350A94-5201-20	1	0	0	0
	RBE703A94-1130-01	1	0	0	0
	RBE703A95-0505-00	1	0	0	0
	RBE703A95-0508-00	1	2	0	0
	RBE703A95-0520-01	1	0	0	0
	RBE703A95-0520-01-11	1	0	0	0
	RBE703A95-0520-01-13	1	0	0	0
	RBE703A95-0520-01-15	1	0	0	0
	RBEA62309-65	1	0	0	0
	RBEA62309-81	1	0	0	0
	RBEA62309-83	1	0	0	0
	RBEA62310	1	0	0	0
	RBT18025-13	1	0	0	0
	RBW109-3101-58-1-1	1	0	0	0
	RBW109-3101-58-2-1	1	0	0	0

Part Specifications

Specifications could not be found.

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		REVISIONS		DATE	INITIAL	APPROVE
REV	ECR	DESCRIPTION				
1		-81 REARRANGED TOP SHELF TOOLS. -83 RECONFIGURED BOTTOM SHELF TOOL ARRANGEMENT TO BETTER FIT RED BARN TOOLS. -45 RECONFIGURED TOP AND BOTTOM SHELF TOOL ARRANGEMENT TO BETTER FIT RED BARN TOOLS. ADDED LAMINATED LOCATOR CARD AND LANYARD COMPONENTS.		9/22/2009	WP	
2		REDRAWN TO USE HELPPRODUCTS TOOLS AND ALLOW FOR 3 DRAIN HOSES.		1/25/2010	WP	RW
2A		ADDED NEW RED BARN PHOTOS.		2/11/2010	RJC	RW
3		-81 REARRANGED TOP SHLF TOOLS. -83 RARRANGED BOTTOM SHELF TOOL CUSHION TO ACCOMMODATE NEW DIGITAL TORPEDO LEVEL. ADDED SECTION A-A TO CLARIFY CUT OUT FOR RBEA94-3701-00. CHD CUTOUT DEPTH FOR RBEA94-3700-A. RBEA94-5201-20 & RBEA93-3501-20. -45 REARRANGED TOP AND BOTTOM SHELF CUSHIONS TO ACCOMMODATE NEW DIGITAL TORPEDO LEVEL. CHD CARD INFORMATION FOR L&S.		2/18/2010	RJC	
4		-83 REARRANGED TOOL CUTOUTS. ADDED CUT OUT FOR RBEA62310. -45 UPDATED CARD.		3/9/2010	WP	
4A		-49 & -91 CHD QTY. FROM 3 TO 1 SET. UPDATED LAYOUT PHOTOS.		5/26/2010	RJC	
4B		-87 & -89 ADDED ONE TO EACH QTY.		7/21/2010	WP	RW
4C		-91 ADDED CONTAINER FOR RBEA93-3205-00-1 & RBEA93-3205-00-03 NUTS & BOLTS.		10/27/2010	WP	DW
5		-81 DELETED CUTOUT NOTCHES FOR RBE-RDGS-15.		6/20/2011	RJC	RW
6		CORRECTED DRAIN HOSE 1/4" FROM RBEA93-0502-01 TO RBEA93-0520-01. -83 CHD FOAM CUTOUTS FOR RBEA93-3500-00, RBEA93-3500-20, RBEA93-3200-20 & RBEA93-3317-20 FOR BETTER FIT. -45 UPDATED CARD.		2/27/2012	RJC	DW
7		-83 CHD TOOL LAYOUT. ADDED NEW DESIGN FOR DRAIN HOSES & CUTOUTS FOR INDIVIDUAL GUILLS. CHD CUTOUT FOR RBEA94-3700-A FOR TIGHTER FIT. -45 UPDATED CARD.		1/9/2013	RJC	SE
7A		-45 CORRECTED ITEM Q P/N FROM RBEA93-3305-02 TO RBEA93-3305-20. CHD F QTY. FROM 8 TO 1. ADDED 5 DRAIN HOSE QTY. 2. CHD LOCATION D1 & D2 TO D1 AND X1, X2, & X3 TO X.		4/11/2013	RJC	RJC
8		-81 CHD DIM WAS 4.75 & 4.44. -83 CHD CUTOUT LOCATION FOR RBEA94-3700-A. -45 CORRECTED 1/4" & TOOL DESCRIPTION TO MATCH CURRENT DRAWINGS.		10/24/2013	CFS	DW
9		-81 CHD CUTOUT FOR RBE-350HYD (NEW GAUGE). CHD CUTOUT FOR RBEA94-3700-C TO FIT BETTER. -83 CHD CUTOUT FOR RBEA94-3700-A TO SECURE TOOLS BETTER.		3/25/2014	RJC	DW
10	15-0038	UPDATED TO NEW DRAFTING STANDARDS. -83 CHD FOAM TO ACCOMMODATE SNAP-ON INCLINOMETER. -45 CHD CARD TO SHOW NEW TOOL LAYOUT WITH SNAP-ON INCLINOMETER.		2/11/2015	DPD	JAG
11	16-0149	-81 ADDED DETAIL SHEET. REPLACED RBE-RDGS-15 WITH RBT18025-13 AND MOVED TO -83. ADDED RBW109-3101-58-1 & RBW109-3101-58-2. CHD MATERIAL WAS 120 BLACK E ETHAFOAM 220. BLACK. -82 ADDED DRAWING. -83 ADDED DETAIL SHEET. CHD TOOL LAYOUT. CHD DIM WAS 4X R.64 IS 3X 44 X 45. DELETED DIMS 73 (X2), 1P (X2), 1.38 (X2) & R.73 (X4) SPHERE. AND ADDED DIMS 78. 1.48 & 1.25. CHD FOAM WAS 120 BLACK E ETHAFOAM 220. BLACK. MOVED RBEA93-3400-00, RBEA94-3201-20 & RBEA93-3501-20 TO -81. -43 RBE-RDGS-15 REPLACED W/ RBT18025-13. -45 REARRANGED TOOLS TOP AND BOTTOM. ADDED RBW109-3101-58-1, RBW109-3101-58-2, RBT18025-13, -77, -87, & -89.		9/20/2016	RJC	JAG
12	17-0013	-81 CHD DIM WAS .820 & .82. -83 CHD DETAIL ORGANIZATION: REMOVED DIM 3X 9.88, 3X 1.38, 33.47, 2X 34.17, 7.225, 8.07, 7.13. ADDED DIM 97.75, 30.13, 5.49 12.77, R.13, R1.38, 5X R.50, 2X R.63, 6X R.13, R.50. CHD DIM WAS 10.24 & 3X 10.24. WAS 2X 34.86 & 3X 34.68. WAS 12.33 & 8.80. WAS 11.565 & 11.57. -45 REARRANGED TOOLS ON BOTTOM SHELF. UPDATED ITEM 12 & 13 TOOL NUMBERS.		1/24/2017	SM	JAG

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WORK ORDER
NO. 170532MCS
1801-13

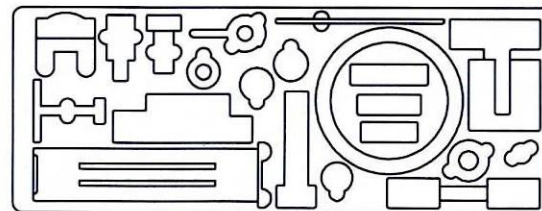
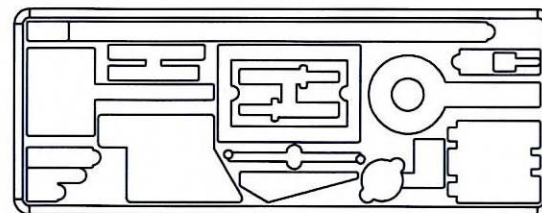
NOTE:
7 FT. HOSES MUST COUPLE IN CUTOUT. MIN TRIM ACCEPTABLE.

DART AEROSPACE		AS350-355 FIELD MAINTENANCE KIT	
		DWO NO. RBEA62309	REV 12
MATL. REKT. FINISH SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES DECIMALS: .010 FRACTIONS: 1/8" ANGLES: 90° SURFACES: 125		
DRAWN BY: CLOUGH CHECKED: DUERFELDT OPFS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	1. BREAK ALL SHARP EDGES .015 X .45" OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009 USED ON MODEL AS350/355		
SCALE 1:8	DATE 9/20/2016	SHEET 1 OF 8	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
11	16-0149	ADDED RBW109-3101-58-1 & RBW109-3101-58-2 TO BOM. -43 RBE-RDGS-15 REPLACED W/ RBT18025-13.	9/21/2016	RJC	JAG
12	17-0013	CHD B/O INFO WAS RBE703A95-0250-01 & RBE703A95-0250-01 -1, -11, -13, -15. WAS RBW109-3101-58-1 & RBW109-3101-58-2. WAS RBW109-3101-58-2 & RBW109-3101-58-2-1. CHD DESCRIPTION WAS ENGINE & HYDRAULIC DRAIN TUBE & ENGINE & HYDRAULIC. -77 CHD QTY WAS 1 & 4.	1/24/2017	SM	JAG

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
				1	DAMPER SPANNER WRENCH		RBE-350DAMPER	1
				1	HYD. ACCUMULATOR FITTING GAUGE		RBE-350HYD	1
				1	1/R DRIVESHAFT BEARING RUNOUT GAUGE		RBE-350TRDS	1
				1	MGB/ROTOR BRAKE RETAINING NUT WRENCH		RBE350A93-3200-20	1
				1	1/R G/B INPUT FLANGE HOLDING WRENCH		RBE350A93-3205-00T	1
				1	ENGINE G/B INPUT FLANGE HOLDING WRENCH		RBE350A93-3205-00E	1
				1	1/R HUB SOCKET		RBE350A93-3300-20	1
				1	1/R HUB LOCK WRENCH		RBE350A93-3302-02	1
				1	1/R BODY EXTRACTOR TOOL		RBE350A93-3303-02	1
				1	TAIL GEARBOX WRENCH		RBE350A93-3305-20	1
				1	TAIL GEARBOX SEAL EXTRACTOR		RBE350A93-3307-00	1
				1	1/R HUB BUSHING REPLACEMENT TOOL		RBE350A93-3312-03	1
				1	ROTATING STAR REPLACEMENT WRENCH		RBE350A93-3316-20	1
				1	TAIL ROTOR HUB INSERT TOOL		RBE350A93-3317-20	1
				1	DRIVE SHAFT THIMBLE		RBE350A93-3400-00	1
				1	BEARING EXTRACTOR		RBE350A93-3500-00	1
				1	EXTRACTION TOOL HYD. PUMP PULLEY BEARING		RBE350A93-3501-20	1
				1	M/R BLADE TRIM TAB TOOLS		RBE703A94-1130-01	1
				1	JAMMING TOOL PEDALS		RBE350A94-2704-00	1
				1	RIGGING PIN SET		RBE350A94-2706-00	1
				1	1/R BLADE LOCK FIXTURE		RBE350A94-2708-01	1
				1	1/R ACCELERATOR SUPPORT		RBE350A94-3301-00	1
				1	SWASHPLATE IMMOBILIZING TOOL LONG BRACE		RBE350A94-3700-A	1
				1	SWASHPLATE IMMOBILIZING TOOL ADJUSTABLE BRACE		RBE350A94-3700-C	1
				1	M/R RIGGING TOOL		RBE350A94-3701-00	1
				1	CARTRIDGE, DUMMY, FUEL		RBE350A94-5201-20	1
				1	ENGINE & HYDRAULIC		RBE703A95-0250-01 -1, -11, -13, -15	1
				1	TGB DRAIN TUBE		RBE703A95-0505-00	1
				1	MGB DRAIN TUBE		RBE703A95-0508-00	1
				1	LINEAR SCALE		RBT18025-13	1
				1	AS350/355 ENGINE STRUT		RBEA62310	1
				1	HAMMER, STEEL		RBW109-3101-58-1-1	1
				1	HAMMER, ALUMINUM		RBW109-3101-58-2-1	1
				1	INCLINOMETER		RBE-350INCLINOMETER	1
				1	TEMPERATURE PROBE		RBE-350TEMP	1
		-65		1	LAMINATED LOCATION CARD	LAMINATED CARD		6
	B/O	-67		1	LANYARD	COATED STEEL	Ø1/16 X 12 CARR LANE #CL-2-C	N/5
	B/O	-69		1	GROMMET	NICKEL-PLATED BRASS	SIZE ØØ, Ø.42 ØD (MCMMASTER-CARR #86625F31)	N/5
	B/O	-71		1	EYELET	COATED COPPER	SIZE 2 (CARR-LANE #CL-194-TERM-2)	N/5
	B/O	-73		4	RIVET	ALUMINUM	Ø3/16 X 3/8 - 1/2 (MCMMASTER-CARR #97526A421)	N/5
	B/O	-75		1	FERRULE	ALUMINUM	Ø1/16 X 3/8 (MCMMASTER-CARR #3896131)	N/5
	B/O	-77		4	ELASTIC RETAINER W/HOOKS	BUNGEE CORD	Ø1/4 X 10in.	1
	B/O	-79		1	HARD CASE	PLASTIC	PELICAN #APP-1700-E	N/5
	B/O	-81		1	TOP SHELF CUSHION	ETHAFOAM 220, BLACK	1.81 X 13-5/8 X 35-5/8 (CASE SOLUTIONS)	3 & 4
	B/O	-82		1	TOP CUSHION STIFFENER	COROPLAST, BLACK	6mm X 13-5/8 X 35-5/8 (CASE SOLUTIONS)	5
	B/O	-83		1	BOTTOM SHELF CUSHION	ETHAFOAM 220, BLACK	3-1/4 X 13-5/8 X 35-5/8 (CASE SOLUTIONS)	6 & 7
	B/O	-87		1	REMOVE BEFORE FLIGHT	NYLON	NAS 1756-12	1
	B/O	-89		1	CABLE TIES	NYLON	(MCMMASTER-CARR #7189K31)	1
	B/O	-91		1	VIAL FOR FLANGE WRENCH BOLTS	POLYPROPYLENE	Ø2.03 O.D. X 1.58in. (MCMMASTER-CARR #5274761)	1
	B/O			1	DART PLACARD	ALUMINUM	RB41011	N/5



DART AEROSPACE	
TITLE AS350-355 FIELD MAINTANANCE KIT	
DWG NO. RBEA62309	REV 12
MAT'L _____ REAT _____ DREA _____ FINISH _____ SPEC _____	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8" .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES ± 1/8"	
1. BREAK ALL SHARP EDGES .015 X 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: CLOUGH CHECKED: DUERFELDT OPFS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	
USED ON MODEL AS350/355	
SCALE 1:1	DATE 9/20/2016
SHEET 2 OF 8	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					